

Date: Monday, 11/21/2005 11:50:57 AM
 User: Linda Lacelle









Process Sheet

| | | | |
|-----------------------|--|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SADDLE, OUTBOARD, LH, 206 |
| Job Number | : 24847 | | |
| Estimate Number | : 10818 | | |
| P.O. Number | : NIA | Part Number | : D26651 |
| This Issue | : 11/21/2005 S.O. No. : NIA | Drawing Number | : D2665 REV. B |
| Prsht Rev. | : NC | Project Number | : NIA |
| First Issue | : NIA Type : MACHINED PARTS | Drawing Revision | : B |
| Previous Run | : NIA | Material | : NIA |
| Written By | : SEE COMMENT BELOW | Due Date | : 12/21/2005 Qty: 12 Um: Each |
| Checked & Approved By | : SEE COMMENT BELOW | | |
| Comment | : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|---|---|
| 1.0 | D6101003 | 7075-T7351 2X6.25X7.875 |
| |  |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) B 24891 x 2 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length Batch no B22241 x 9 En / ml 05/12/30 12 | | |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| |  |  |
| Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. En 05/12/28 1-Inspect part number and batch number are programmed correctly. J.L 05/12/28 2-Fixturing W/O No. NIA 3-Fixturing Inspection last completed on 05/12/28 by En 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr En 06/01/14 En / ml 05/12/30 12 | | |
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
| |  |  |
| Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet En 06/01/14 12 | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| |  |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE En 06/01/14 12 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/01

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 11:50:58 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 24847

Part Number: D26651

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/01/14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:01:14

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 06 01 30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CL 06/01/31 12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 343

CL 06/01/31 12

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5.5 06/02/01 12 PD 06/02/01

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | |
|---|-----------------------------|
| DART AEROSPACE LTD | Work Order: 24847 |
| Description: 206 Saddle, Outboard, Left side | Part Number: D2665-1 |
| Inspection Dwg: D2665 Rev. B | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.100 | 0.140 | | 0.126 | 0.127 | 0.122 | 0.119 | | |
| B | 0.100 | 0.140 | | 0.123 | 0.121 | 0.127 | 0.117 | | |
| C | 0.100 | 0.140 | | 0.120 | 0.127 | 0.125 | 0.120 | | |
| D | 0.210 | 0.230 | | 0.219 | 0.223 | 0.221 | 0.217 | | |
| E | 1.245 | 1.255 | | 1.246 | 1.247 | 1.248 | 1.248 | | |
| F | 1.245 | 1.255 | | 1.246 | 1.249 | 1.248 | 1.248 | | |
| G | 5.990 | 6.010 | | 6.001 | 6.002 | 6.003 | 6.002 | | |
| H | 0.510 | 0.515 | | 0.512 | 0.512 | 0.512 | 0.512 | | |
| I | 1.674 | 1.684 | | 1.676 | 1.676 | 1.677 | 1.677 | | |
| J | 2.495 | 2.505 | | 2.495 | 2.497 | 2.500 | 2.500 | | |
| K | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | 0.257 | 0.257 | | |
| L | 0.312 | 0.317 | DT8686 | 0.312 | 0.312 | 0.312 | 0.312 | | |
| M | 0.235 | 0.240 | | 0.239 | 0.237 | 0.238 | 0.238 | | |
| N | 0.100 | 0.140 | | 0.112 | 0.112 | 0.105 | 0.122 | | |
| O | 0.540 | 0.560 | | 0.542 | 0.543 | 0.542 | 0.545 | | |
| P | 0.490 | 0.510 | | 0.499 | 0.494 | 0.496 | 0.496 | | |
| Q | 3.609 | 3.619 | | 3.610 | 3.610 | 3.609 | 3.609 | | |
| R | 2.470 | 2.510 | | 2.500 | 2.500 | 2.501 | 2.501 | | |
| S | 0.240 | 0.270 | | 0.251 | 0.251 | 0.253 | 0.245 | | |
| T | 0.100 | 0.180 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| U | 0.313 | 0.318 | DT8686 | 0.317 | 0.318 | 0.318 | 0.318 | | |
| V | 1.125 | 1.145 | | 1.132 | 1.130 | 1.127 | 1.139 | | |
| W | 1.565 | 1.585 | | 1.570 | 1.568 | 1.567 | 1.577 | | |
| X | | | | | | | | | |
| Y | | | | | | | | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|-------------------|------------------|
| Measured by: E.D. | Audited by: S.G. |
| Date: 05/12/29 | Date: 06/01/14 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 | KJ/RF | |

0.265

| | | | |
|---|--|---------------------|----------------|
| ART AEROSPACE LTD | | Work Order: | 24847 |
| Description: 206 Saddle, Outboard, Left side | | Part Number: | D2665-1 |
| Inspection Dwg: D2665 Rev. B | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | 0.120 | 0.120 | 0.119 | 0.119 | | |
| B | 0.100 | 0.140 | | 0.122 | 0.120 | 0.126 | 0.121 | | |
| C | 0.100 | 0.140 | | 0.126 | 0.127 | 0.125 | 0.127 | | |
| D | 0.210 | 0.230 | | 0.218 | 0.220 | 0.220 | 0.220 | | |
| E | 1.245 | 1.255 | | 1.249 | 1.250 | 1.250 | 1.250 | | |
| F | 1.245 | 1.255 | | 1.249 | 1.250 | 1.250 | 1.250 | | |
| G | 5.990 | 6.010 | | 6.000 | 6.001 | 6.001 | 6.001 | | |
| H | 0.510 | 0.515 | | 0.512 | 0.512 | 0.512 | 0.512 | | |
| I | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.680 | | |
| J | 2.495 | 2.505 | | 2.497 | 2.500 | 2.500 | 2.499 | | |
| K | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | 0.257 | 0.257 | | |
| L | 0.312 | 0.317 | DT8686 | 0.312 | 0.312 | 0.312 | 0.312 | | |
| M | 0.235 | 0.240 | | 0.238 | 0.238 | 0.238 | 0.238 | | |
| N | 0.100 | 0.140 | | 0.120 | 0.121 | 0.122 | 0.121 | | |
| O | 0.540 | 0.560 | | 0.543 | 0.548 | 0.543 | 0.547 | | |
| P | 0.490 | 0.510 | | 0.502 | 0.504 | 0.503 | 0.506 | | |
| Q | 3.609 | 3.619 | | 3.612 | 3.612 | 3.612 | 3.612 | | |
| R | 2.470 | 2.510 | | 2.499 | 2.495 | 2.499 | 2.496 | | |
| S | 0.240 | 0.270 | | 0.244 | 0.245 | 0.244 | 0.244 | | |
| T | 0.100 | 0.180 | | 0.144 | 0.140 | 0.145 | 0.141 | | |
| U | 0.313 | 0.318 | DT8686 | 0.318 | 0.318 | 0.318 | 0.318 | | |
| V | 1.125 | 1.145 | | 1.137 | 1.138 | 1.138 | 1.140 | | |
| W | 1.565 | 1.585 | | 1.576 | 1.577 | 1.579 | 1.572 | | |
| X | | | | | | | | | |
| Y | | | | | | | | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|---------------------|-------------|-------------|
| Measured by: | <i>me</i> | Audited by: | <i>J. G</i> |
| Date: | 05/12/30 / 06/01/14 | Date: | 06/01/14 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat: Added Dim. U-W & DT8683, DT8686 | K"RF | |

| | | | |
|---|--|---------------------|----------------|
| ART AEROSPACE LTD | | Work Order: | 24877 |
| Description: 206 Saddle, Outboard, Left side | | Part Number: | D2665-1 |
| Inspection Dwg: D2665 Rev. B | | Page 1 of 1 | |

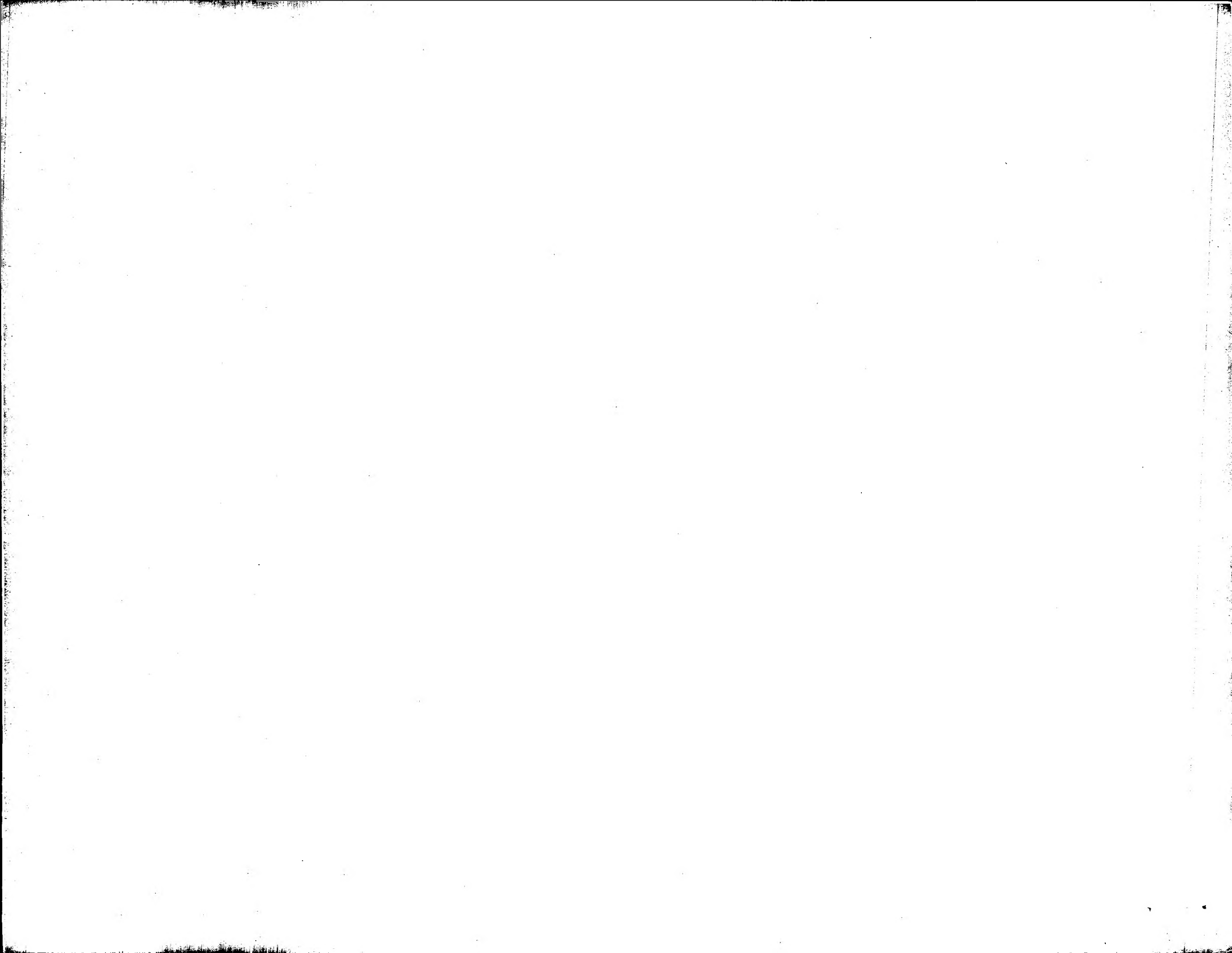
Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | 0.120 | 0.118 | 0.121 | 0.119 | | |
| B | 0.100 | 0.140 | | 0.120 | 0.118 | 0.118 | 0.121 | | |
| C | 0.100 | 0.140 | | 0.115 | 0.112 | 0.110 | 0.113 | | |
| D | 0.210 | 0.230 | | 0.220 | 0.221 | 0.221 | 0.220 | | |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.249 | | |
| F | 1.245 | 1.255 | | 1.250 | 1.251 | 1.250 | 1.250 | | |
| G | 5.990 | 6.010 | | 6.001 | 6.001 | 6.000 | 6.001 | | |
| H | 0.510 | 0.515 | | 0.512 | 0.512 | 0.512 | 0.512 | | |
| I | 1.674 | 1.684 | | 1.680 | 1.680 | 1.679 | 1.679 | | |
| J | 2.495 | 2.505 | | 2.499 | 2.500 | 2.500 | 2.499 | | |
| K | 0.257 | 0.262 | DT8683 | 0.259 | 0.259 | 0.259 | 0.259 | | |
| L | 0.312 | 0.317 | DT8686 | 0.314 | 0.314 | 0.314 | 0.314 | | |
| M | 0.235 | 0.240 | | 0.238 | 0.237 | 0.237 | 0.237 | | |
| N | 0.100 | 0.140 | | 0.120 | 0.121 | 0.120 | 0.120 | | |
| O | 0.540 | 0.560 | | 0.545 | 0.546 | 0.549 | 0.546 | | |
| P | 0.490 | 0.510 | | 0.504 | 0.501 | 0.505 | 0.504 | | |
| Q | 3.609 | 3.619 | | 3.611 | 3.612 | 3.612 | 3.612 | | |
| R | 2.470 | 2.510 | | 2.500 | 2.500 | 2.500 | 2.496 | | |
| S | 0.240 | 0.270 | | 0.244 | 0.244 | 0.244 | 0.244 | | |
| T | 0.100 | 0.180 | | 0.143 | 0.146 | 0.140 | 0.140 | | |
| U | 0.313 | 0.318 | DT8686 | 0.318 | 0.318 | 0.318 | 0.318 | | |
| V | 1.125 | 1.145 | | 1.142 | 1.142 | 1.142 | 1.142 | | |
| W | 1.565 | 1.585 | | 1.577 | 1.575 | 1.576 | 1.577 | | |
| X | | | | | | | | | |
| Y | | | | | | | | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|---------------------|
| Measured by: | <i>[Signature]</i> |
| Date: | 05/12/30 / 06/01/14 |

| | |
|-------------|-------------|
| Audited by: | <i>J.G.</i> |
| Date: | 06/01/14 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 | KJ/RF | |



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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

| | | | |
|-------------------|--------------------------|------------------------------|----------------|
| Work Order No | : 0024847 | Department Code: | |
| Project Name | : D2665-1 | Burden Flags | : NNNNNNNN |
| Project For | : WK551 | WO Status | : Open |
| Work Order Type | : Main | Invoice State | : Not Invoiced |
| Main WO Number | : | Invoice Date | : |
| House Part Number | : D2665-1 | Invoice Number | : |
| Description | : Saddle, LH Fwd Aft Out | Invoice Amount | : 0.00 |
| Manufactured | : Yes | | |
| Amount Req'd | : 12 | Order Entry No | : |
| Amount Done | : 0 | OE Value | : 0.00 |
| Start Date | : 11-17-05 | | |
| Est Finish Date | : 12-21-05 | Est Margin | : 0.000% |
| Act Finish Date | : | Actual Margin | : 0.000% |
| Drawings Req'd | : No | | |
| Ok for Approval | : | | |
| Approval Rec'd | : | \$0 Posted to Finished Goods | |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | 0.00 | 0.00 | 0.00 | | |
| Production Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | 0.00 | 0.00 | 0.00 | | |
| CNC | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | 0.00 | 0.00 | 0.00 | | |
| Misc. | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | 0.00 | 0.00 | 0.00 | | |
| Total Cost | 0.00 | 0.00 | 0.00 | | |
| Margin | 0.000 | 0.000 | | | |
| Selling Cost | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | 0.00 | 0.00 |
| Profits/(Loss) | 0.00 | 0.00 |